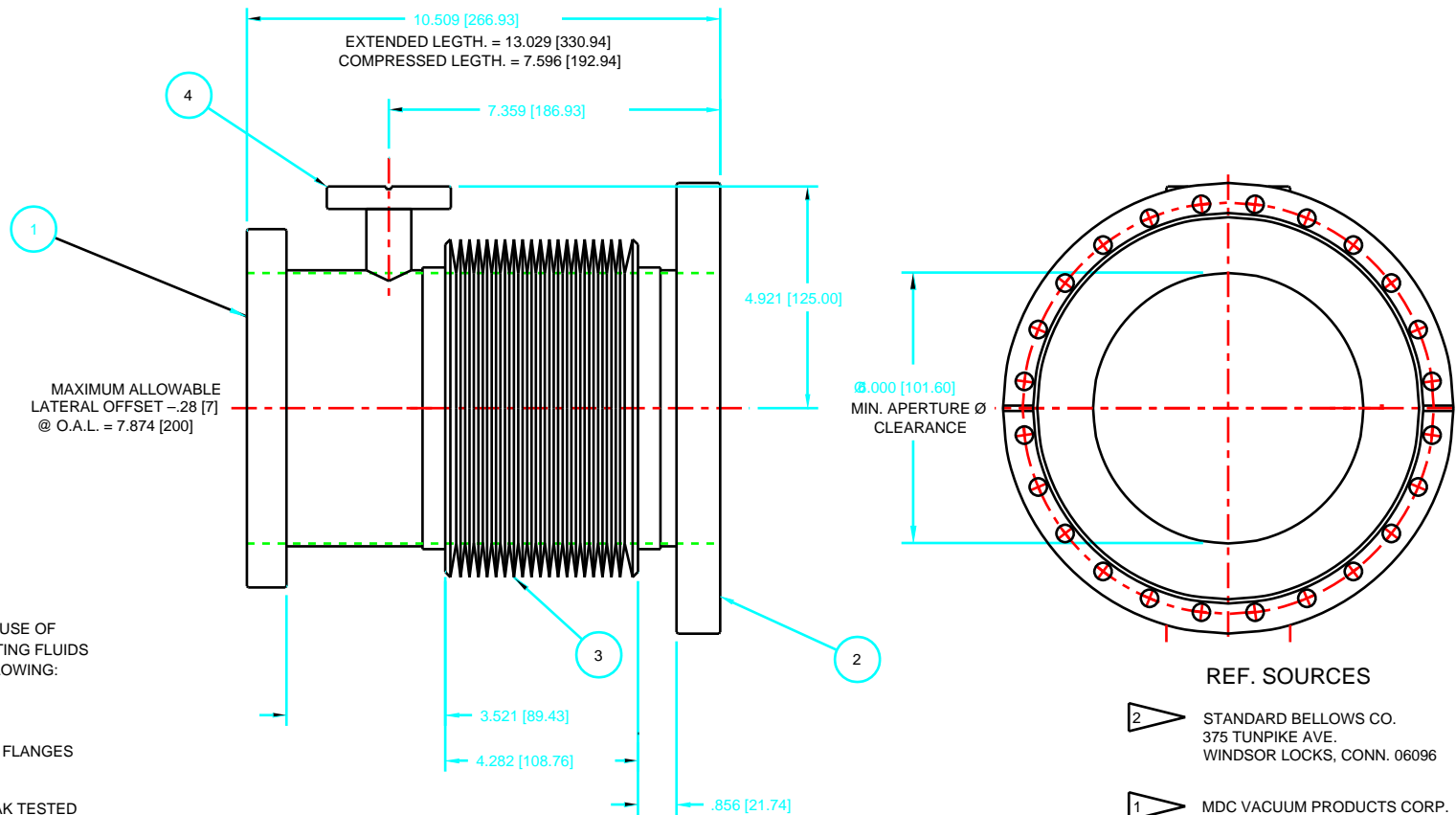


4321



NOTES:

- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
- ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL
- BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS
ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

- KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
- DIMENSIONS IN [] ARE MILLIMETERS

1

2

3

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4	MDC'S CAT. #110012	2 3/4" CF. NONROTATABLE FLANGE	1
3		ST'D. BELLOWS CAT. #750 - 600 - 5 - EE	1
2	MDC'S CAT. #100032	10" CF. ROTATABLE FLANGE	1
1	MDC'C CAT. #110031	8" CF. NONROTATABLE FLANGE	1

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, LOG NUMBER A14778 ALL DIMENSIONS ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
TOLERANCES DECIMALS ANGLES X ± .03 [7620] ± .25 ° XX ± .01 [254] XXX ± .005 [127]		DESIGNED BY MUSCIA CHECKED BY DATE 11/17/93 CHIEF DESIGN ENGINEER DATE TITLE ADVANCED PHOTON SOURCE V2-93 WELDED BELLOWS ASSY. 8" - 10" CF. 6" I.D. X 200mm		
SURFACE ROUGHNESS 125 ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ. SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST. 944 PAINTING AND POLISHING TO BE IN ACCORDANCE WITH LATEST ASST. 944 DO NOT SCALE DRAWING		DESIGNER MUSCIA RESPONSIBLE ENGINEER APPROVED/RELEASED MATERIAL SEE PARTS LIST SCALE HALF SHEET 1 of 1 DRAWING NUMBER 4105090702-960000-00		